

Work Order ID 92947-1

November 12-12 1:35:16 PM

SPHIT-1

\*92947\*

Page 1

HA1

Item ID: D4634-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: MJS

Date: 12-11-12 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4634

A B Wh. 12/02/02

100

0.00

\*100\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

x2

DAS  
07  
03

12/12/04

105

0.00

\*105\*

Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 7:00 pm 12/12/03

Time OUT: 7:00 am 12/12/04

x2

DAS  
07  
03

12/12/04

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Rouze	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabelled	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Other					
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge						
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							



# Work Order ID 92947

November-12-12 1:35:16 PM

\*92947\*

Page 2

Item ID: D4634-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

110

0.00

\*110\*

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D4634-3 and Folio FTA145

Dwg. Rev. \_\_\_\_\_

Folio Rev. \_\_\_\_\_

Visually inspect for proper formation and texture

130

0.00

\*130\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions

140

QC2- Inspect parts off machine FAI/FAIB

0.00

\*140\*

QC

Memo

0.00

Quality Control

DA  
07  
12/12/04

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
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Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											
<b>FAULT CATEGORY</b>																											
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspector Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other																



# Work Order ID 92947

November-12-12 1:35:16 PM

\*92947\*

Page 3

Item ID: D4634-3

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012 Start Qty: 2.00 \*2\*

Cust Item ID:

Required Date: 12/12/2012 Req'd Qty: 2.00 \*2\*

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start \*NR1\*

QC: Date:

SPC (Y/N): Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.  
Code Qty Qty Number Stamp

150 QC5- Inspect part completeness to step on W/O 0.00

\*150\*

QC Memo 0.00

Quality Control

160 Packaging 0.00

\*160\*

Packaging Memo 0.00

Packaging

170 QC21- Final Inspection - Work Order Release 0.00

\*170\*

QC Memo 0.00

Quality Control

HAI

MF  
12-2-25

NCR: Yes / No

**WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width: 100%; border: none;"> <tr> <td style="width: 33%;">Sk d-tube <input type="checkbox"/></td> <td style="width: 33%;">Crosstube <input type="checkbox"/></td> <td style="width: 33%;">Water Jet <input type="checkbox"/></td> <td style="width: 33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Sk d-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY												
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# Picklist Print

November-12-12 1:35:20 PM

Page 1

Work Order ID: 92947

\*92947\*

Parent Item: D4634-3

\*D4634-3\*

Parent Item Name: Middle, Center Ceiling Panel

Start Date: 12/11/2012

Required Date: 12/12/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev. A New Issue 12/05/07 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-62015		Purchased	No			100	sf	1,028,362	14.97	33,266.67			

\*MKYD6185S 080-P3-62015\*

6185 KYDEX .080"

\*\*

Location

Loc Qty

Loc Code

therm

1028.362377

116576

14.148377

121755

1014.214

33.27 sq ft

OK  
12/12/10



NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

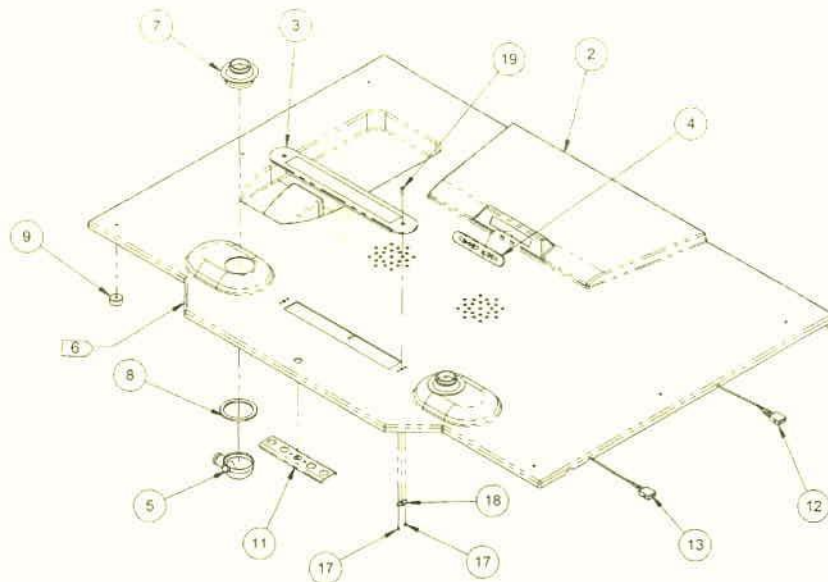
DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____  Part No. _____  NCR No. _____				<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		<b>AGAINST DEPARTMENT/PROCESS</b>  <div style="display: flex; justify-content: space-between;"> <div>           Skid-tube <input type="checkbox"/>            Machining <input type="checkbox"/>            Thermoforming <input type="checkbox"/>            Large Fab <input type="checkbox"/> </div> <div>           Crosstube <input type="checkbox"/>            Small Fab <input type="checkbox"/>            Finishing <input type="checkbox"/>            Composite <input type="checkbox"/> </div> <div>           Water Jet <input type="checkbox"/>            Prod. Eng. Coord. <input type="checkbox"/>            Rec/Store/Packaging <input type="checkbox"/>            Supplier <input type="checkbox"/> </div> <div>           Engineering <input type="checkbox"/>            Quality <input type="checkbox"/>            Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											

FAULT CATEGORY										
<b>Landing Gear</b>			<b>General</b>			<b>Grain</b>		<b>Other</b>		
<input type="checkbox"/> Bending	<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> Cracks	<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Cuffs	<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Wave/Twist in Tube
<input type="checkbox"/> Bend	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Burrs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Countersink	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Drawing	<input type="checkbox"/> Finish	<input type="checkbox"/> Folio
<input type="checkbox"/> Grain	<input type="checkbox"/> Hardware	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Misread	<input type="checkbox"/> Offset	<input type="checkbox"/> Out of Calibration	<input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions
<input type="checkbox"/> Ovalized	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Part Moved	<input type="checkbox"/> Positioned Wrong	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced	<input type="checkbox"/> Temperature/Cure	<input type="checkbox"/> Weld	<input type="checkbox"/> Wrong Stock Pulled
						<input type="checkbox"/> Other				





**D4634-041 FWD, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4694-041, D4712-041, D4647-3, MPNY-750S-9C & D4664-041. WAIT FOR 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-1 FWD CENTER PANEL
- 11) TRANSFER  $\varnothing 0.204$  (#6 DRILL) FROM D4634-1 TO D4694-041 PRIOR TO INSTALLING D4728-047/-051
- 12) INSTALL D4728-047/-051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-1	FWD, CENTER CEILING PANEL
3	1	D4638-1	LED LIGHT
4	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	2	D4647-3	ANGLE
7	2	D4652-1	AIR VALVE
8	2	-	AIR VALVE NUT
9	6	D4664-5	SPACER
10	1	D4694-041	FWD CHANNEL ASSEMBLY
11	1	D4712-041	BRACKET ASSEMBLY
12	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
13	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
14	1	D4732-15	LABEL
15	1	D4732-19	LABEL
16	8	MPNY-750S-9-C	MOUNTING PAD
17	4	MS20426AD3-3	RIVET
18	2	MS21059L3	ANCHOR NUT
19	2	MS24694-S5	SCREW
20	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

SHIP COPY  
RETURN TO  
ENGINEERING  
FOR CONTROL LID  
SUBJECT TO CHANGE  
WITHOUT NOTICE  
WORK ORDER

92947 MJS  
12-11-12

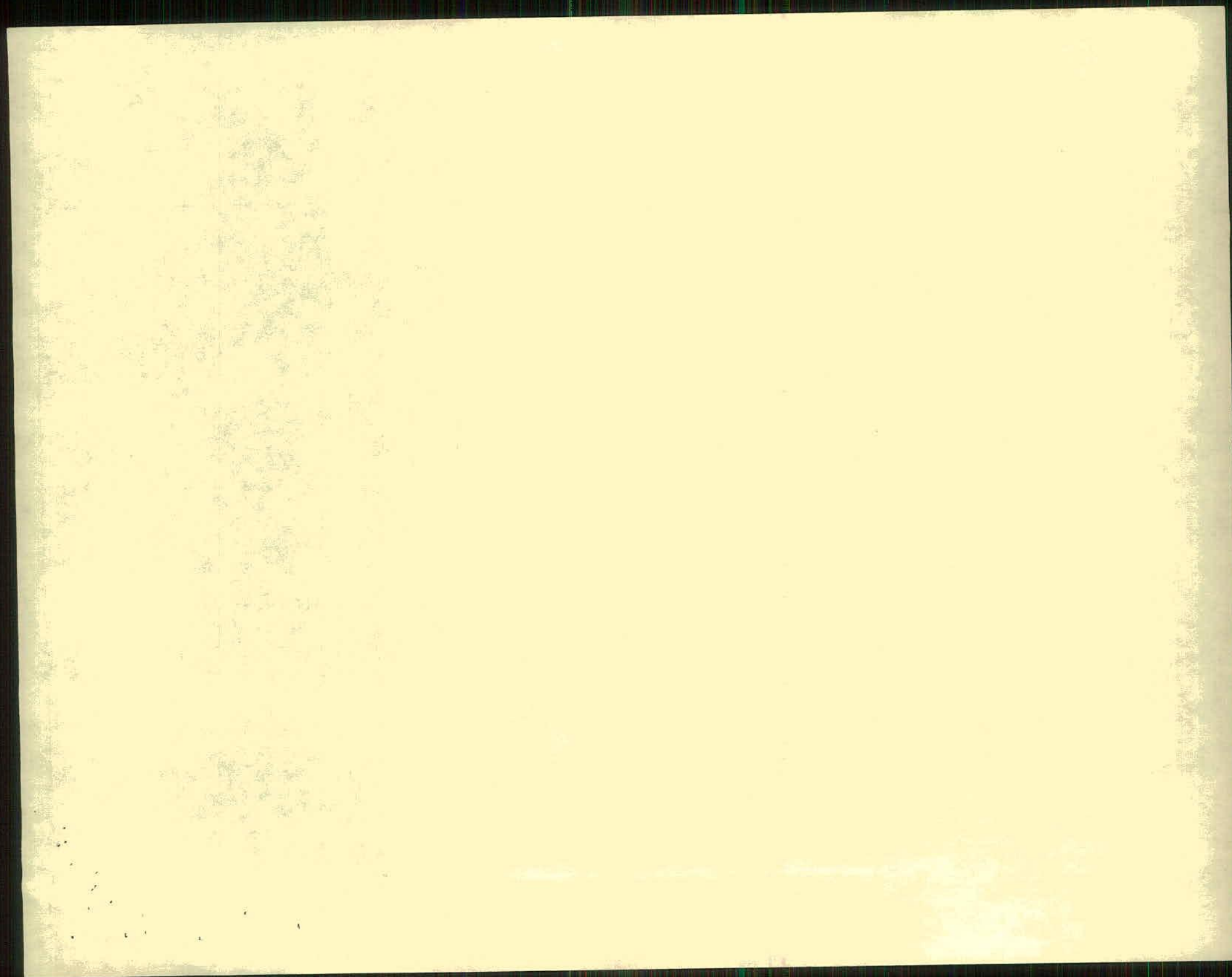
RELEASED  
2012-11-05  
WJ

A	NEW ISSUE	RF	12.07.25
REV	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.07.25		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

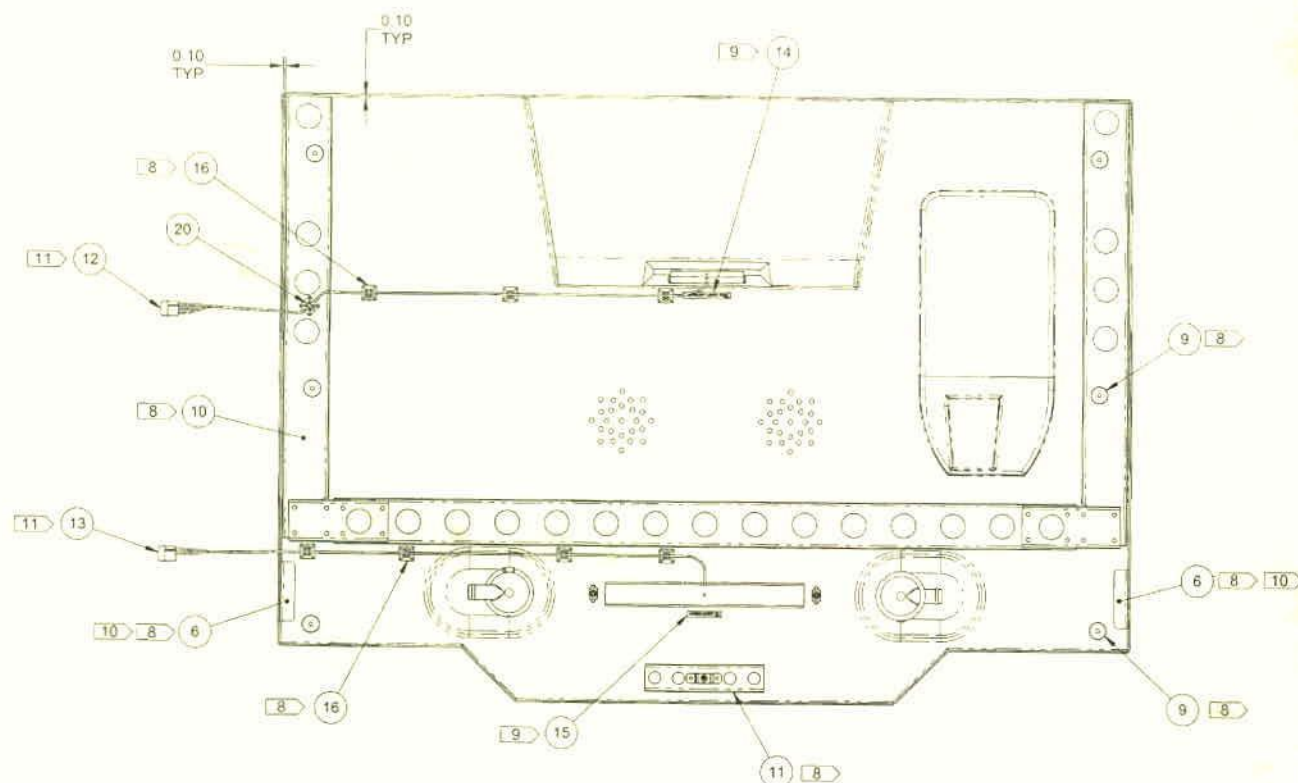
DRAWING NO. **D4634** REV. A  
SHEET 1 OF 14  
TITLE **CENTER CEILING PANELS** SCALE NTS

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WRITTEN PERMISSION FROM DART AEROSPACE LTD





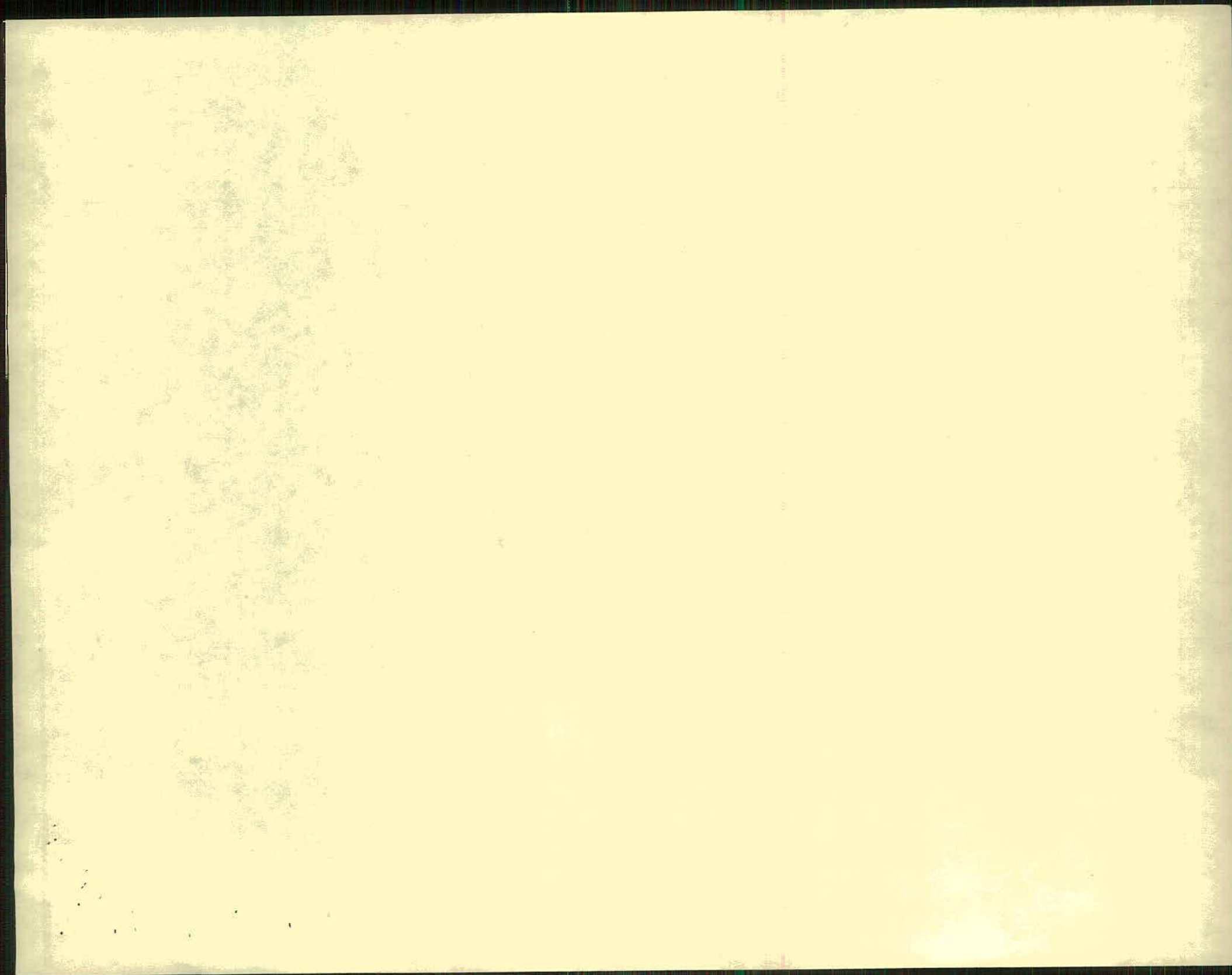
92947



**D4634-041 FWD. CENTER CEILING PANEL ASSY**  
AUXILIARY VIEW

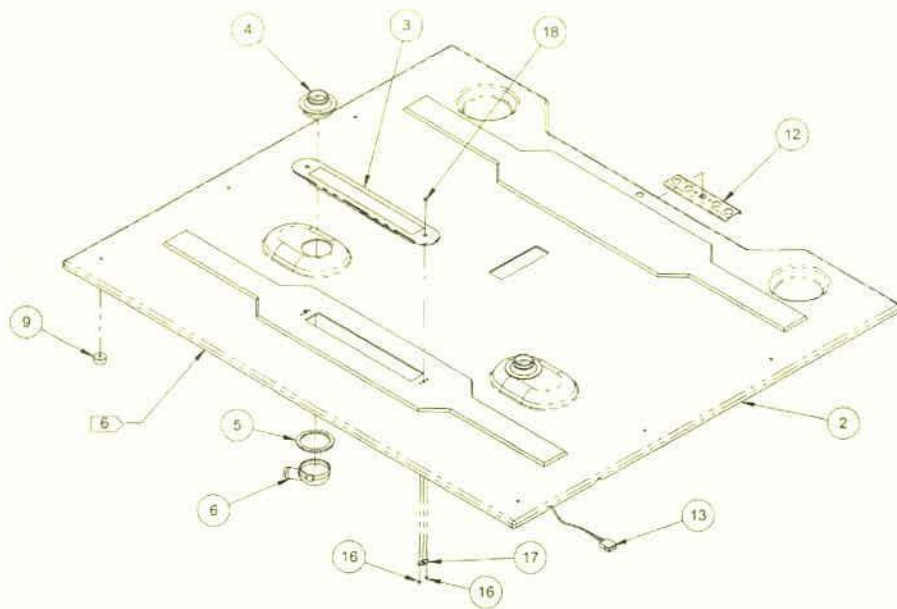
2012-11-05

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 2 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NFS
DATE	12.07.25	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	





92947



ITEM NO.	QTY	PART NUMBER	DESCRIPTION
1	X	D4634-043	MIDDLE, CENTER CEILING PANEL ASSY
2	1	D4634-3	MIDDLE, CENTER CEILING PANEL
3	1	D4639-1	LED LIGHT
4	2	D4652-1	AIR VALVE
5	2		AIR VALVE NUT
6	2	D4646-1	PLENUM CAP ASSEMBLY
7	1	D4647-1	DOUBLER
8	2	D4647-3	ANGLE
9	6	D4664-5	SPACER
10	1	D4694-7	MIDDLE CHANNEL
11	1	D4694-043	MIDDLE CHANNEL ASSEMBLY
12	1	D4712-041	BRACKET ASSEMBLY
13	1	D4728-053	CABIN LIGHT #2 HARNESS ASSEMBLY
14	1	D4732-21	LABEL
15	1	D4732-25	LABEL
16	4	MS20426AD3-3	RIVET
17	2	MS21059L3	ANCHOR NUT
18	2	MS24694-S5	SCREW
19	3	MPNY-750S-9-C	MOUNTING PAD
20	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

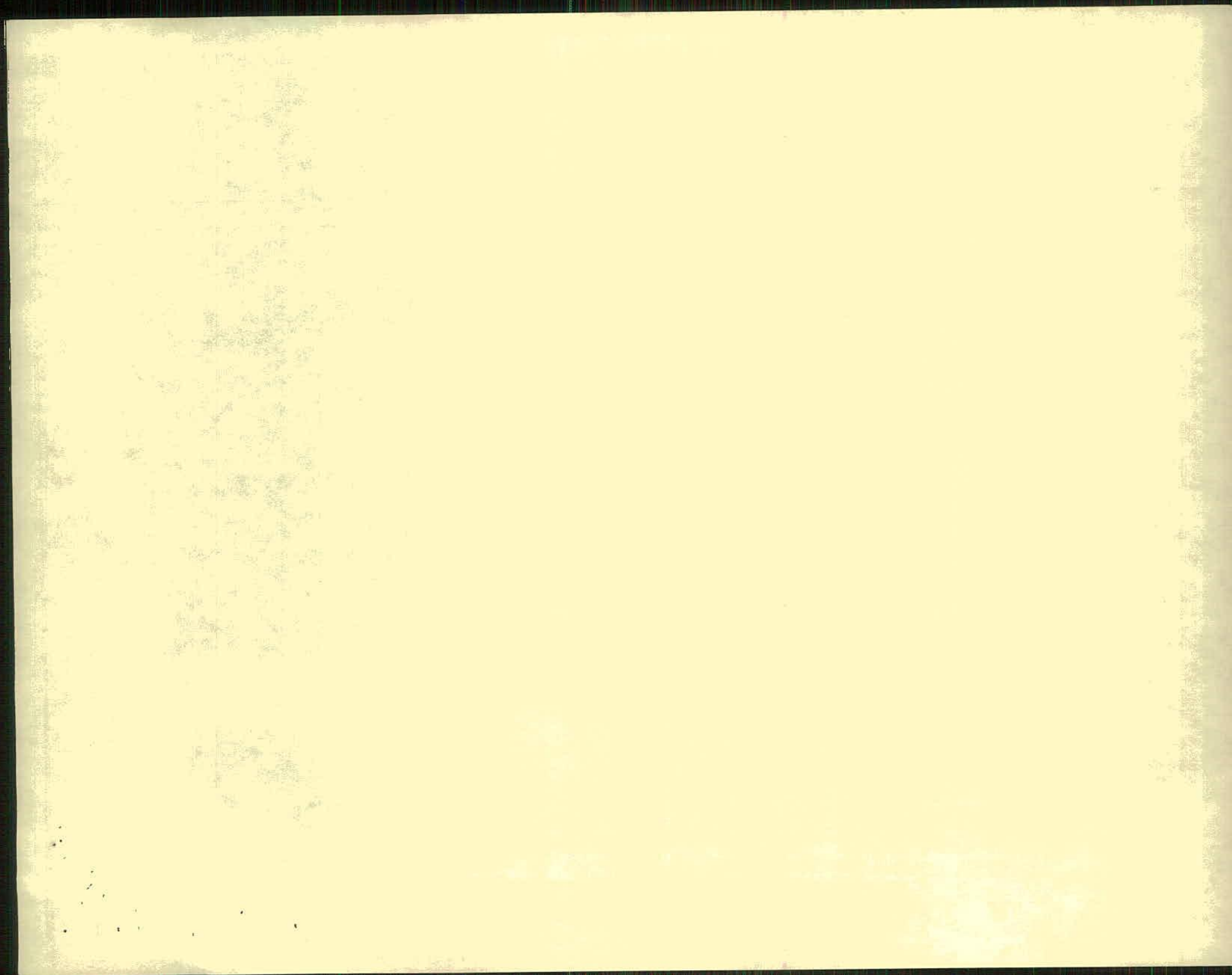
**D4634-043 MIDDLE, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 9.5 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4694-043, D4712-041, D4647-1/-3, MPNY-750S-9C & D4664-041, WAIT FOR 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-3 MIDDLE CENTER PANEL
- 11) TRANSFER  $\varnothing 0.204$  (#6 DRILL) FROM D4634-3 TO D4694-7/-043 PRIOR TO INSTALLING D4728-053
- 12) INSTALL D4728-053 WIRE HARNESS PER QSI 048

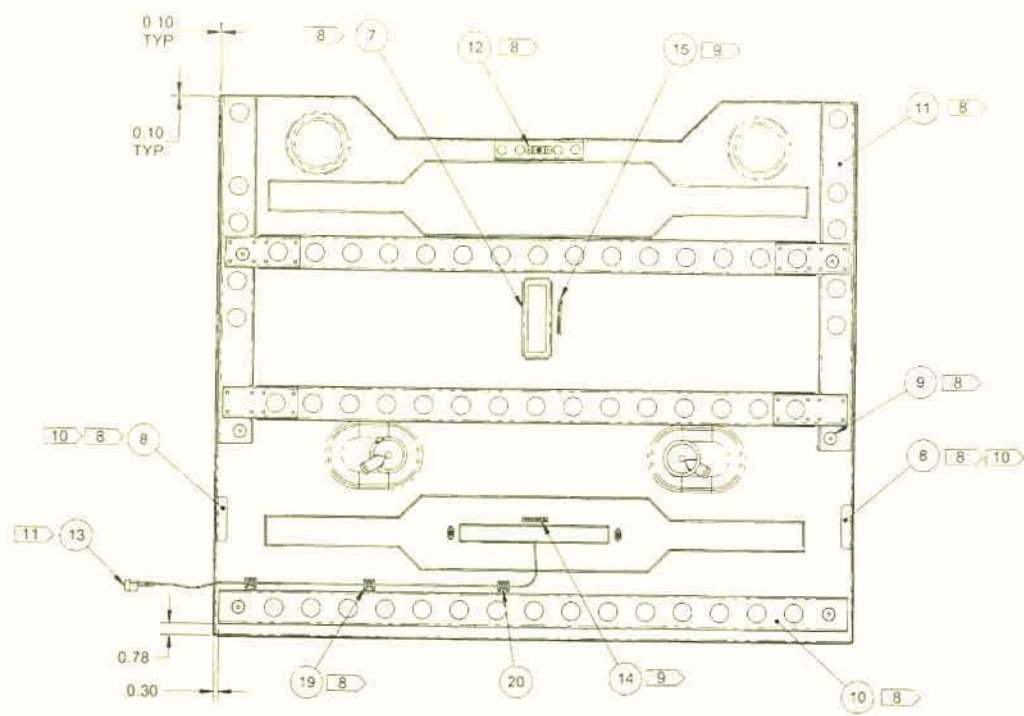
60 2012-11-05

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 3 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR	RF	CENTER CEILING PANELS	NTS
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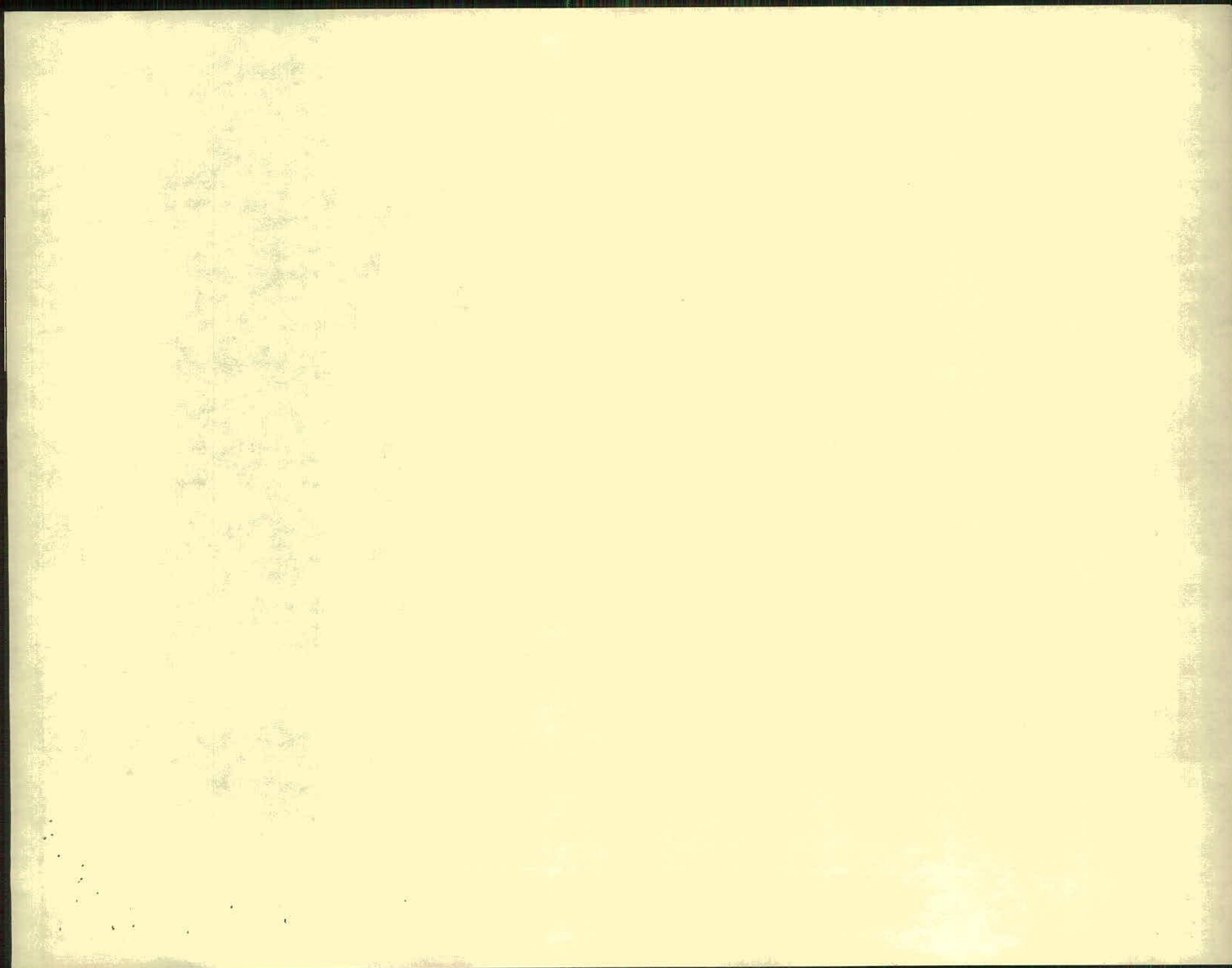
92947



**D4634-043 MIDDLE, CENTER CEILING PANEL ASSY**  
AUXILIARY VIEW

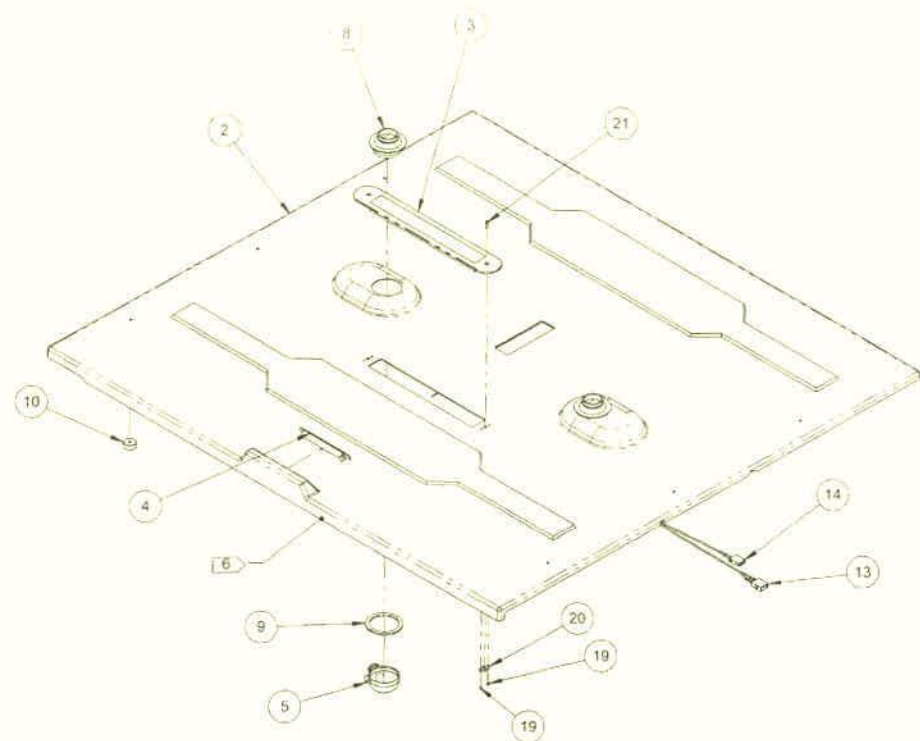
RELEASED  
2012-11-05  
WAP

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG APPR.	<i>[Signature]</i>	<b>D4634</b>	SHEET 4 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CENTER CEILING PANELS</b>	NTS
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ITEM NO.	QTY.	PART NUMBER	DESCRIPTION
1	X	D4634-045	AFT, CENTER CEILING PANEL ASSY
2	1	D4634-5	AFT, CENTER CEILING PANEL
3	1	D4638-1	LED LIGHT
4	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
5	2	D4646-1	PLENUM CAP ASSEMBLY
6	1	D4647-1	DOUBLER
7	2	D4647-3	ANGLE
8	2	D4652-1	AIR VALVE
9	2	-	AIR VALVE NUT
10	6	D4664-5	SPACER
11	1	D4694-045	AFT CHANNEL ASSEMBLY
12	1	D4694-047	AFT CHANNEL ASSEMBLY
13	1	D4728-049	ADVISORY LIGHT (AFT) HARNESS ASSEMBLY
14	1	D4728-055	CABIN LIGHT #3 ASSEMBLY
15	1	D4732-17	LABEL
16	1	D4732-23	LABEL
17	1	D4732-27	LABEL
18	7	MPNY-750S-9-C	MOUNTING PAD
19	4	MS20426AD3-3	RIVET
20	2	MS21059L3	ANCHOR NUT
21	2	MS24694-S5	SCREW
22	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

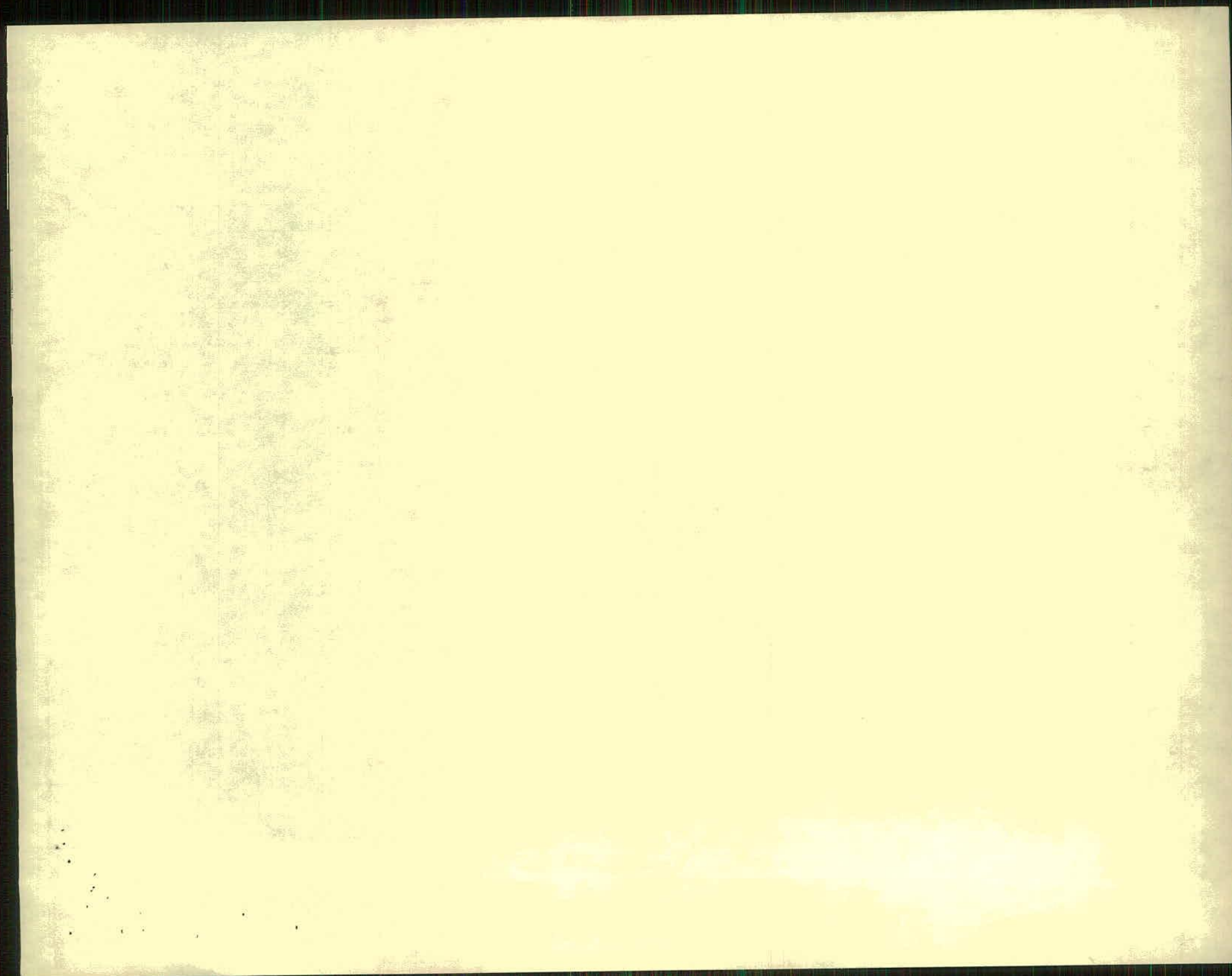
**D4634-045 AFT, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044.6.4, ON SMOOTH SIDE
- 7) WEIGHT: 10.0 lbs
- 8) APPLY A LAYER OF DEVCON PLASTIC WELDER II (0.02 TO 0.04 THICK) TO BOND D4694-045/-047, D4647-1/-3, MPNY-750S-9C & D4664-041, WAIT FOR 24 HOURS TO CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) LOCATE D4647-3 ANGLE USING GROOVE TO ALIGN WITH D4634-5 AFT CENTER PANEL
- 11) TRANSFER Ø0.204 (#6 DRILL) FROM D4634-5 TO D4694-045/-047 PRIOR TO INSTALLING D4728-049/-055
- 12) INSTALL D4728-049/-055 WIRE HARNESS PER QSI 048

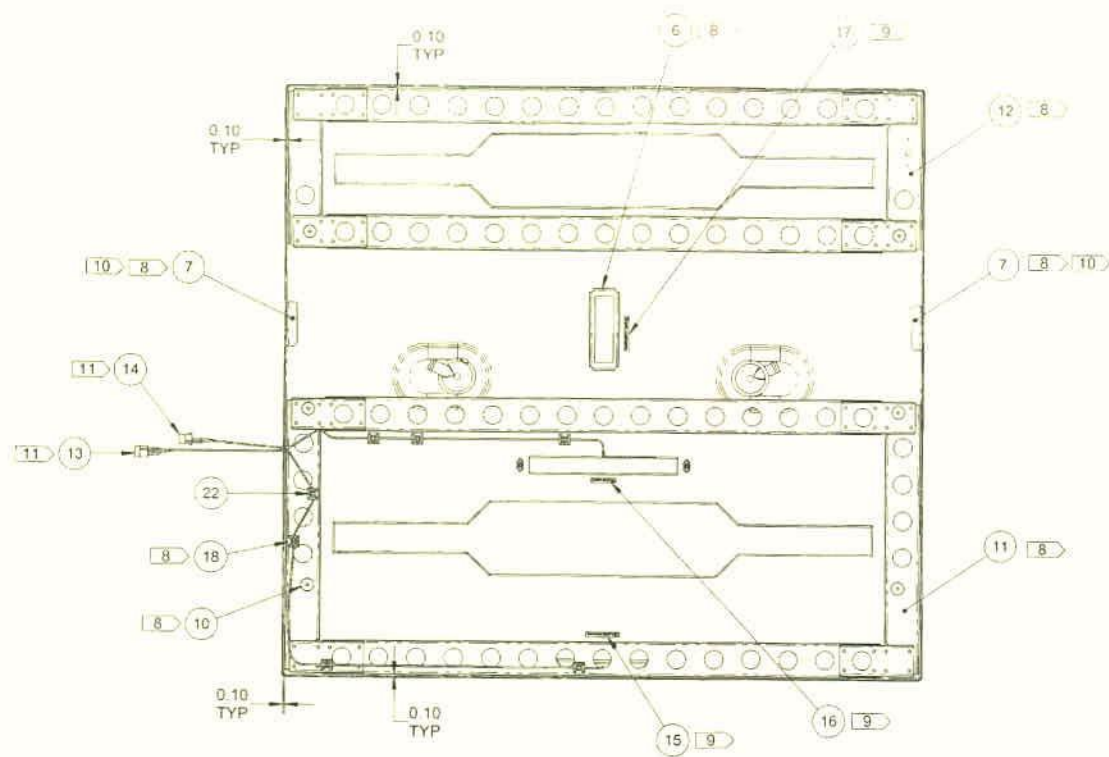
REVISION  
2012-11-05  
MP

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 5 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR	RF	CENTER CEILING PANELS	NTS
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**D4634-045 AFT, CENTER CEILING PANEL ASSY**  
AUXILIARY VIEW

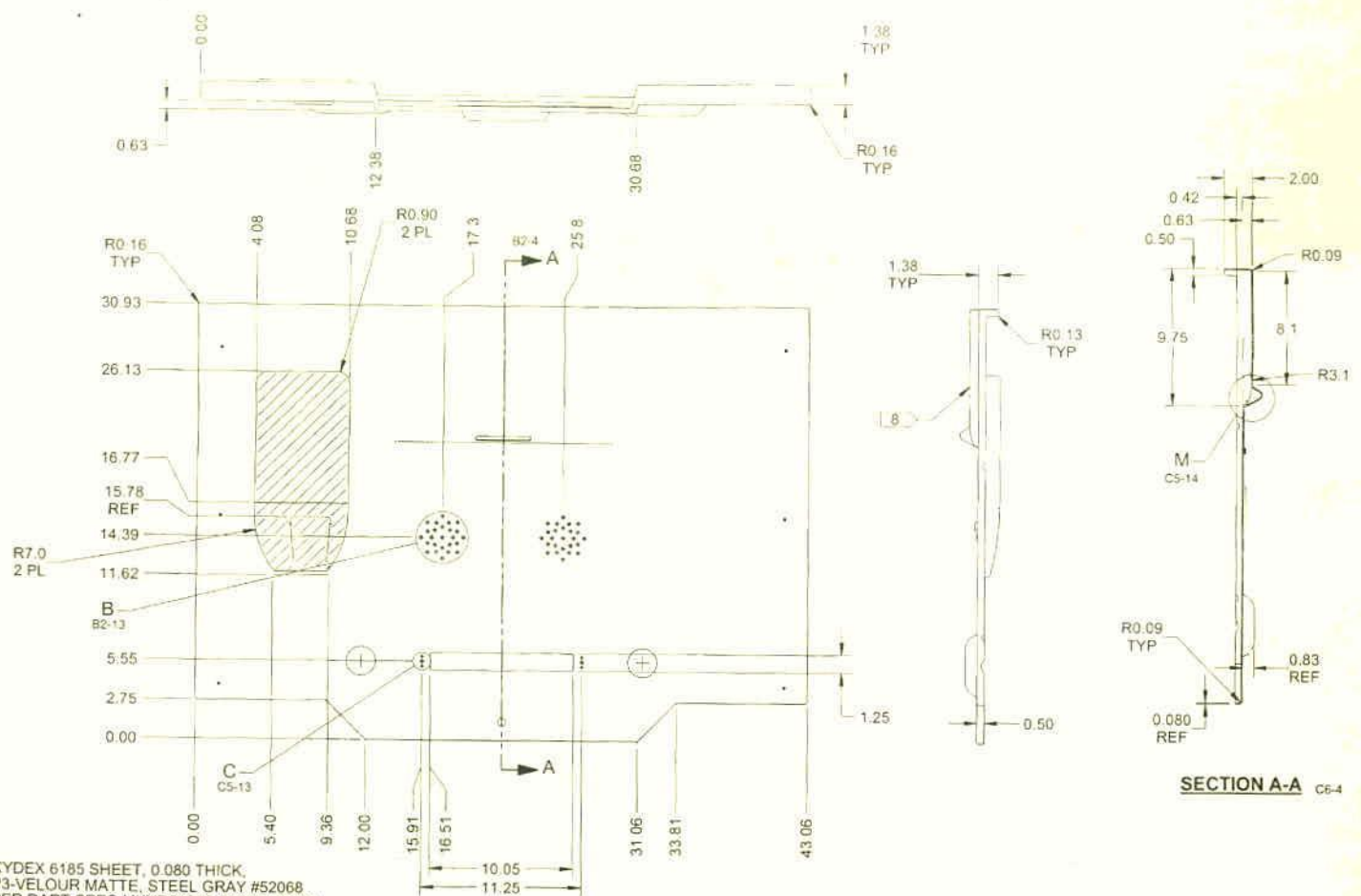
2012-07-05

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DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 6 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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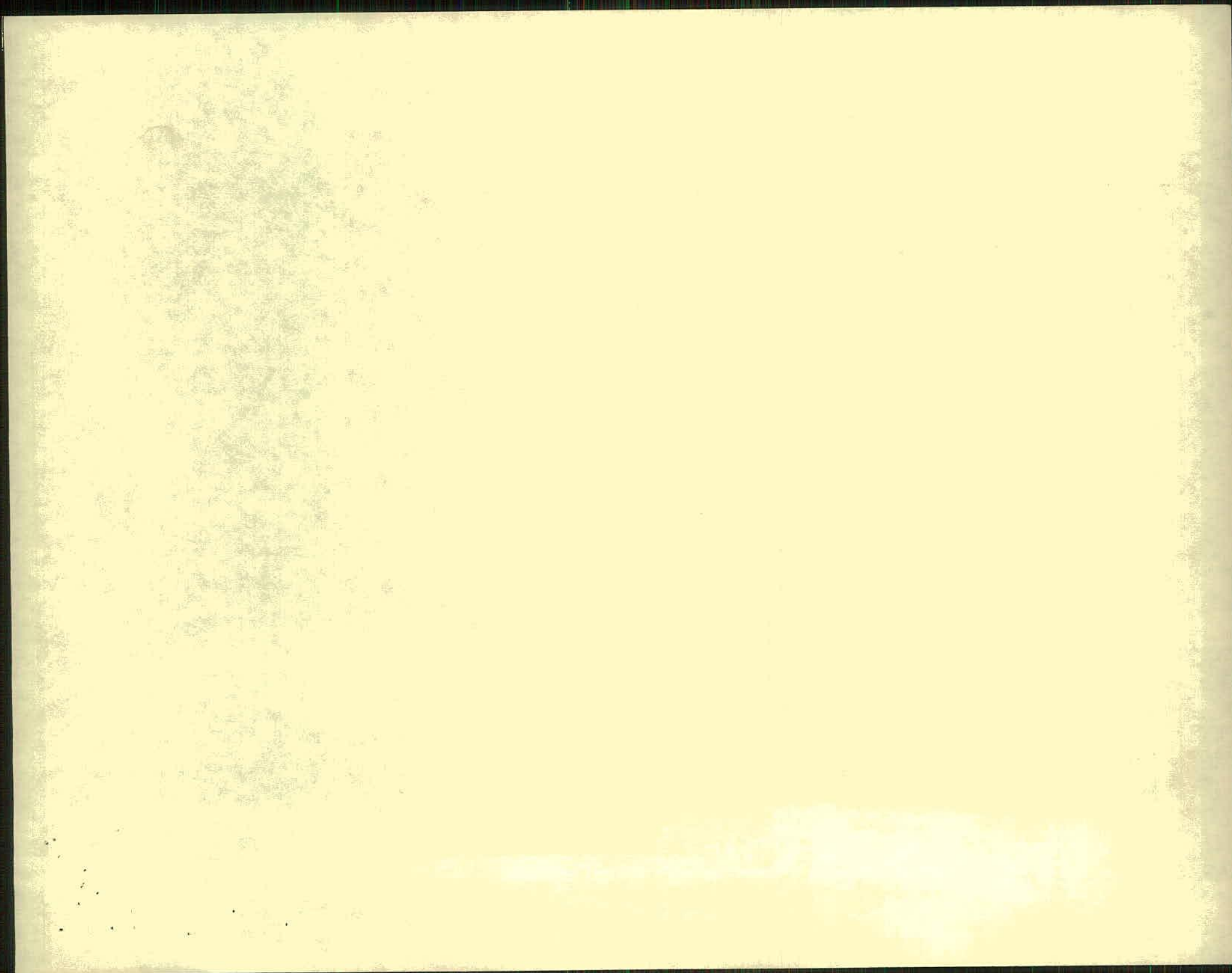


**NOTES:**

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 5.59 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-1 PER TOOL DT9836
- 11) THERMOFORM PER QSI 022 USING DT9844 TOOL  
MIN. THICKNESS AFTER FORMING:  
SHADED AREA = 0.020  
EDGES = 0.060  
ELSEWHERE = 0.070

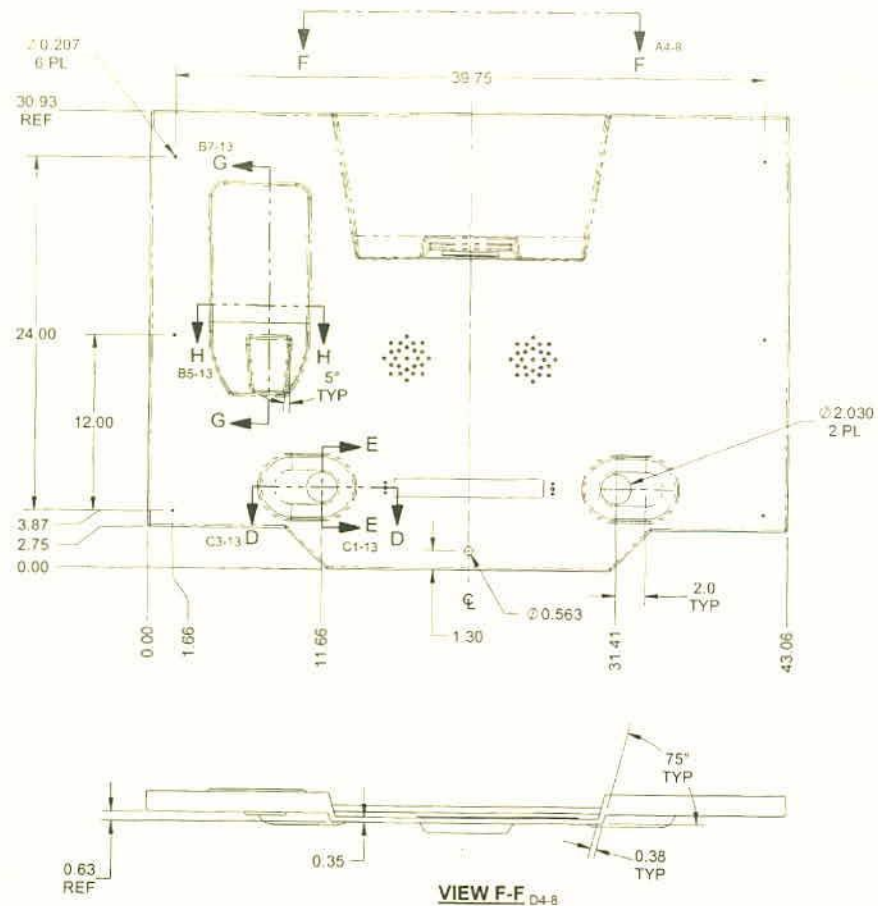
**D4634-1 FWD. CENTER CEILING PANEL**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 7 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
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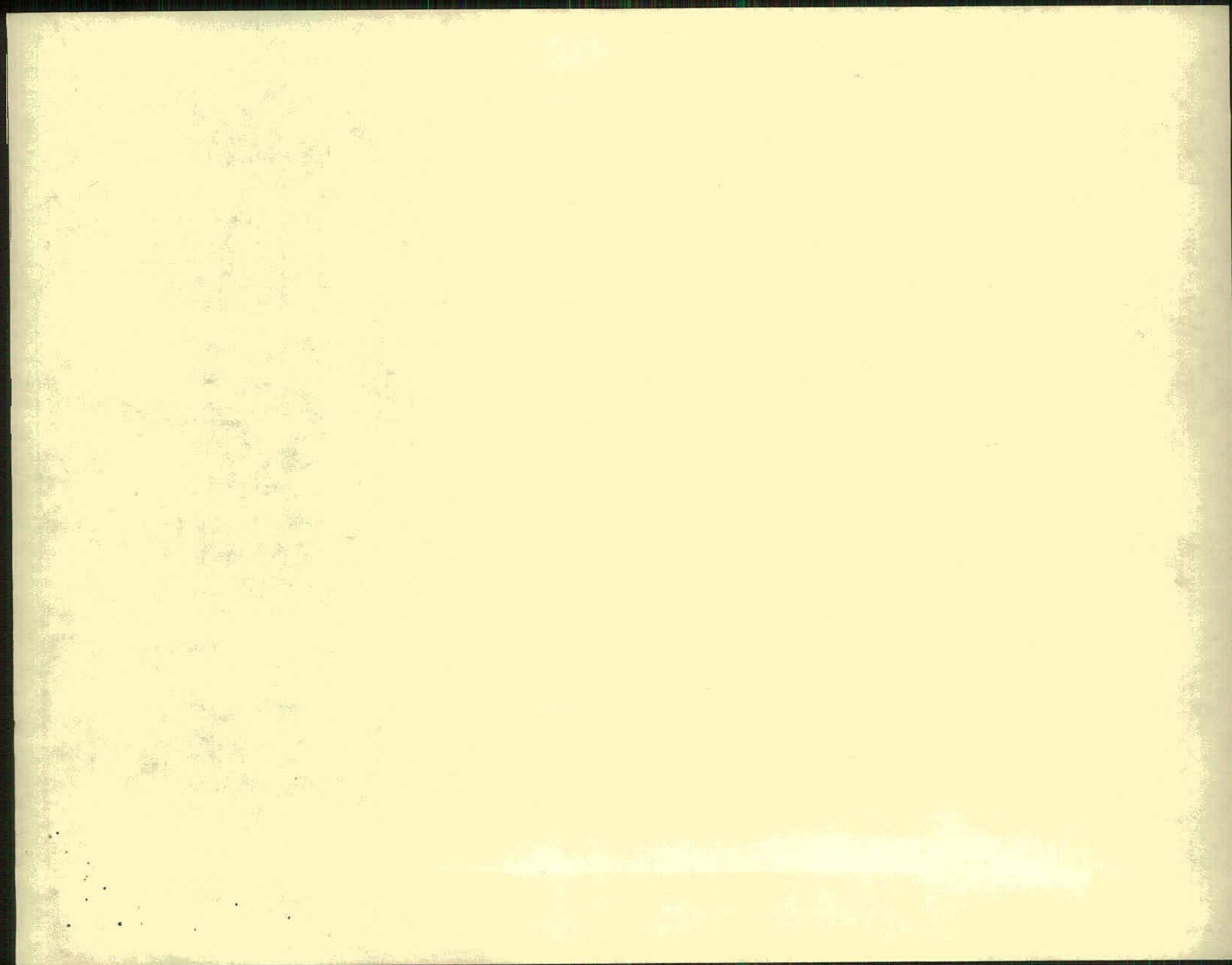


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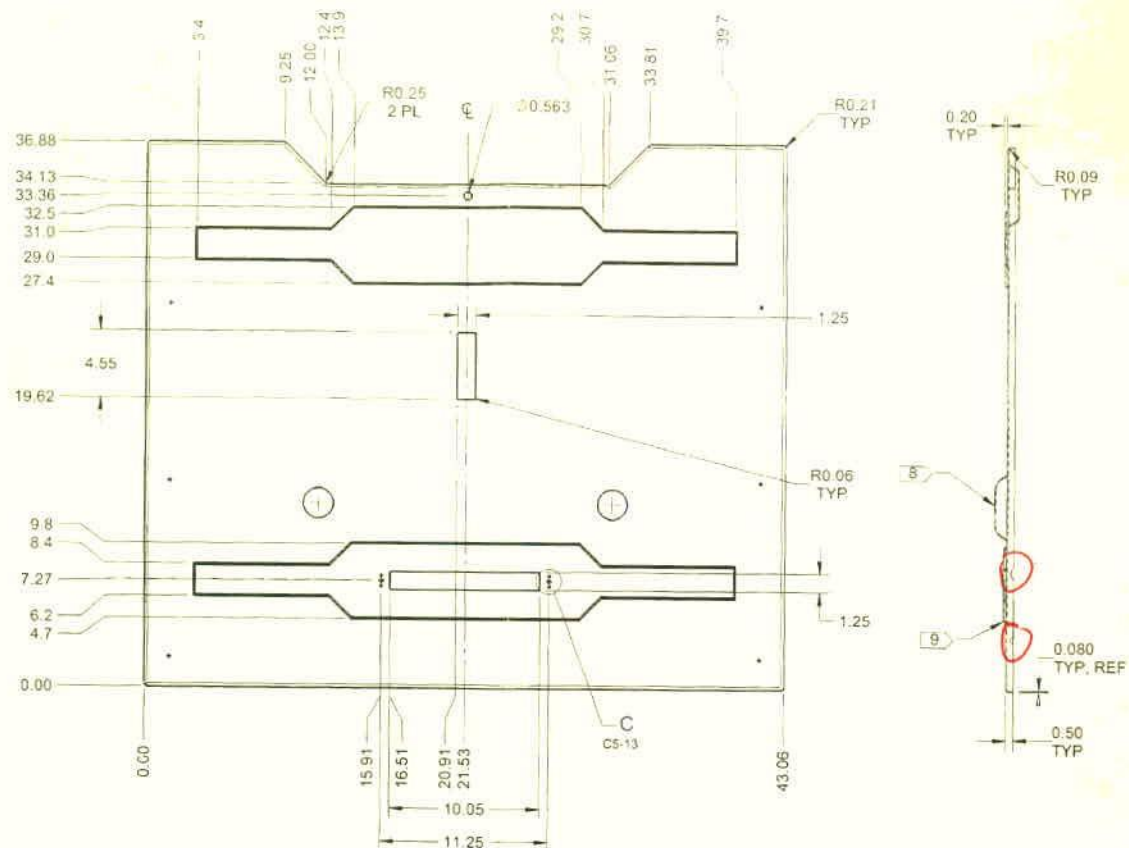
**D4634-1 FWD, CENTER CEILING PANEL**  
AUXILIARY VIEW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 8 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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92947  
0.3



**NOTES:**

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.31 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-3 PER TOOL DT9837
- 11) THERMOFORM PER QSI 022 USING DT9845 TOOL  
MIN. THICKNESS AFTER FORMING:  
EDGES = 0.060  
ELSEWHERE = 0.070

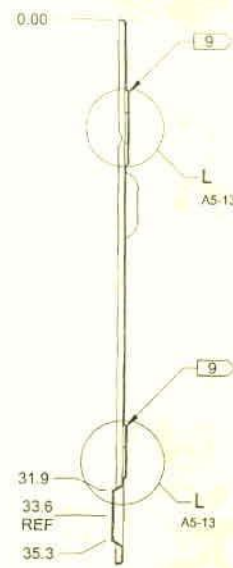
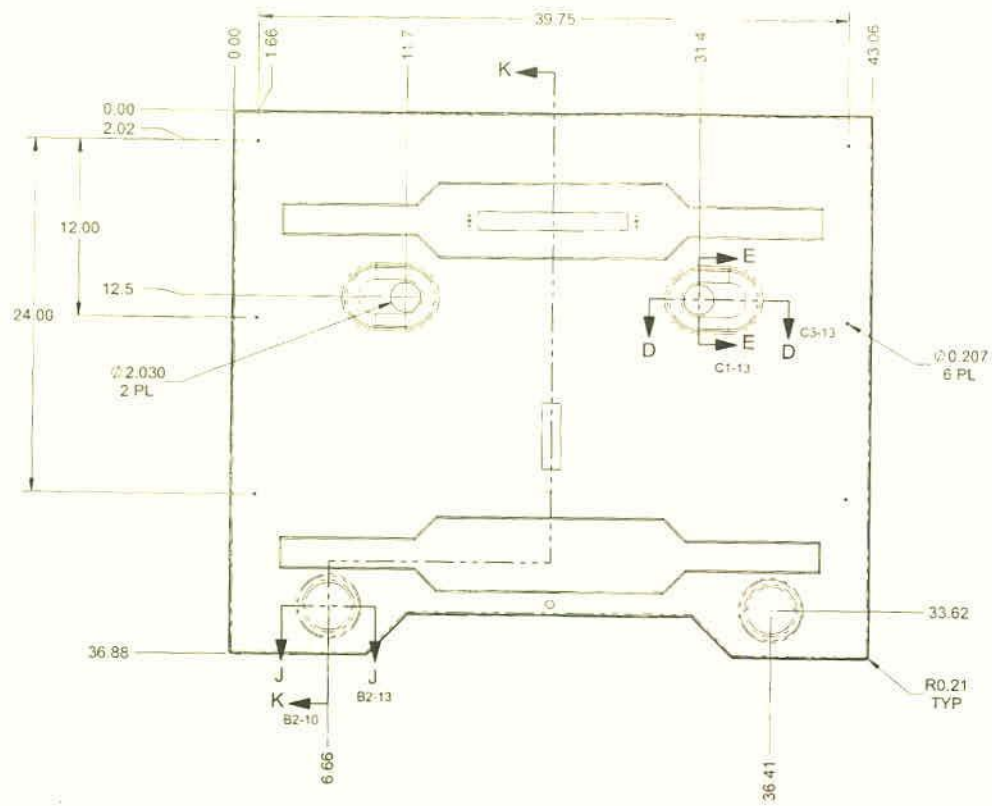
**D4634-3 MIDDLE, CENTER CEILING PANEL**

RELEASED  
2012-11-05  
JWP

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 9 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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92947



SECTION K-K BB-10

D4634-3 MIDDLE, CENTER CEILING PANEL  
AUXILIARY VIEW

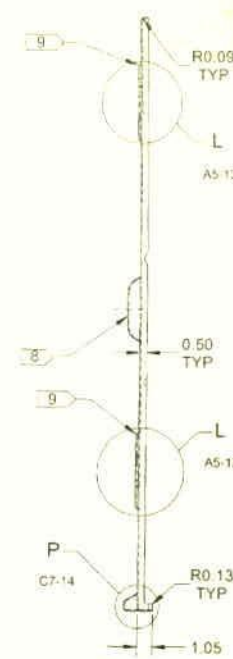
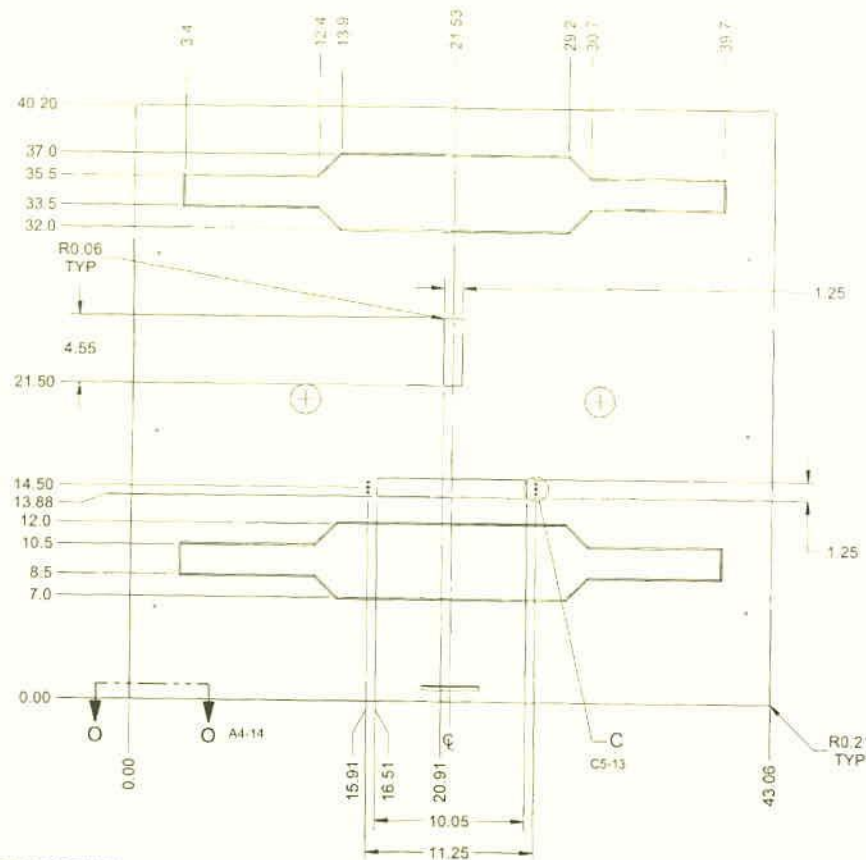
2012-11-05  
JW

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 10 OF 34
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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92943



**NOTES**

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 7.21 lbs
- 8) TEXTURE ON THIS SIDE
- 9) 0.14 RADIUS NOT SHOWN FOR CLARITY
- 10) DRILL & TRIM D4634-5 PER TOOL DT9838
- 11) THERMOFORM PER QSI 022 USING DT9846 TOOL  
MIN. THICKNESS AFTER FORMING:  
EDGES = 0.060  
ELSEWHERE = 0.070

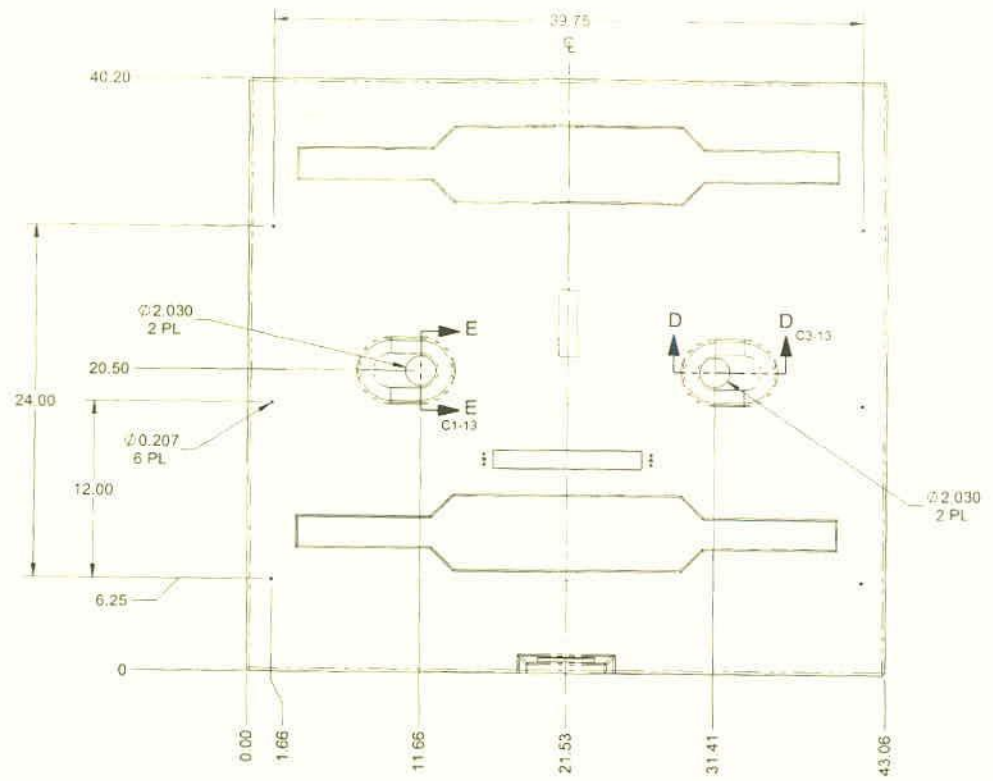
**D4634-5 AFT, CENTER CEILING PANEL**

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D4634</b>	SHEET 11 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>CENTER CEILING PANELS</b>	NTS
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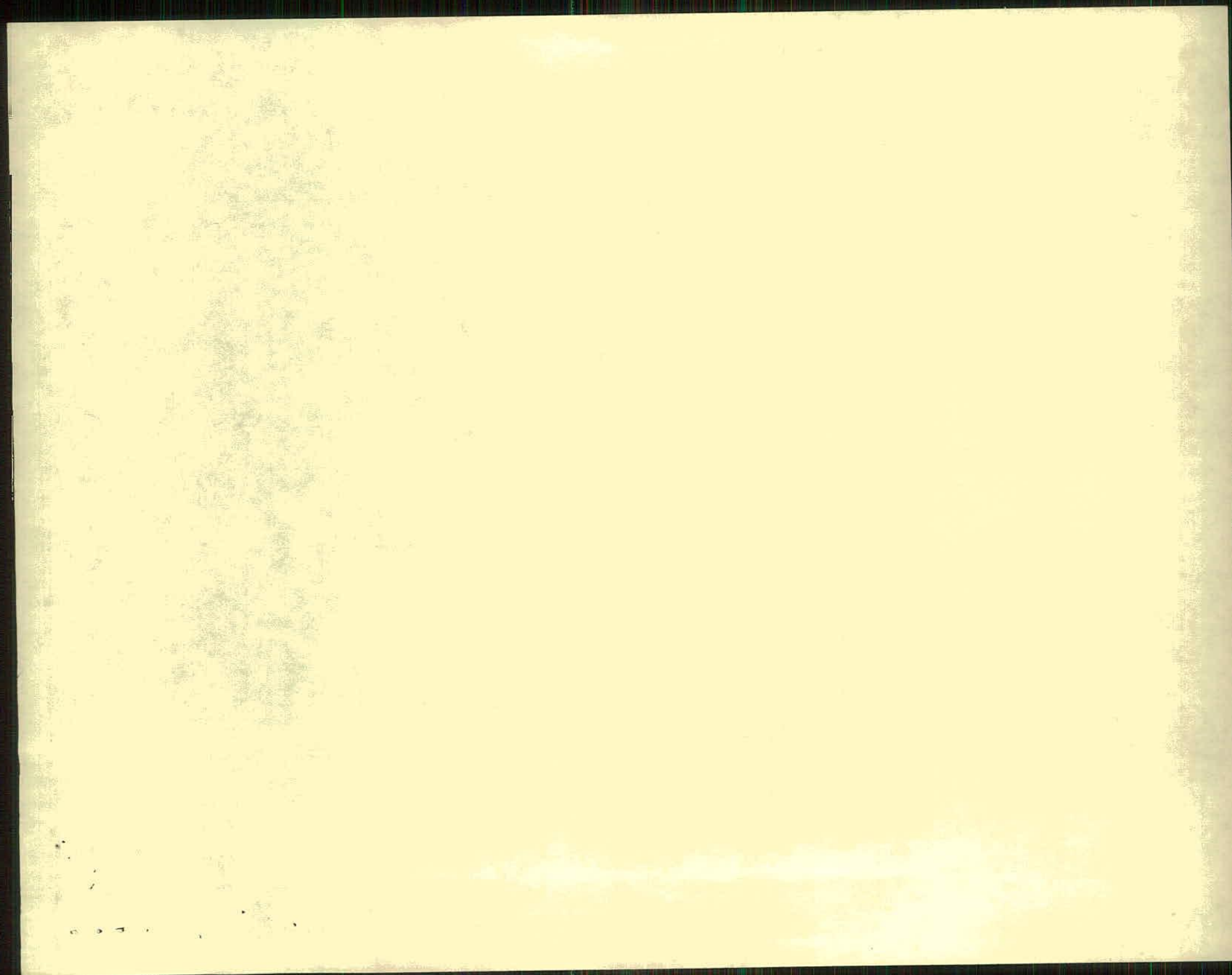
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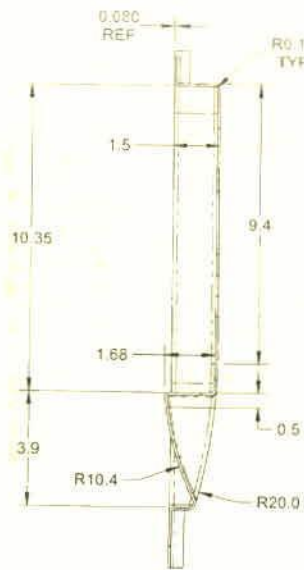
**D4634-5 AFT. CENTER CEILING PANEL**  
AUXILIARY VIEW

2012-07-05  
WHO

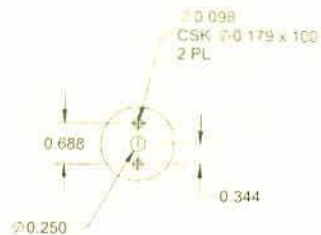
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MFG. APPR.	<i>[Signature]</i>	D4634	SHEET 12 OF 14
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	CENTER CEILING PANELS	NTS
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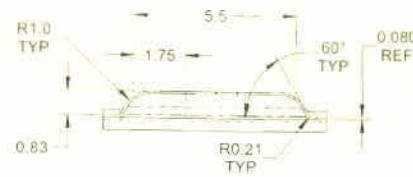
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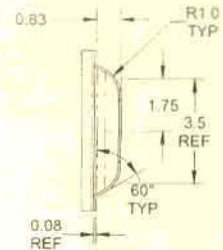
**SECTION G-G**  
SCALE 4X CS-8



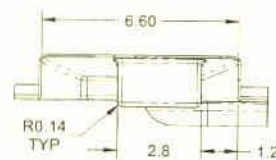
**DETAIL C**  
SCALE 4X B7-7  
B4-9  
B4-11



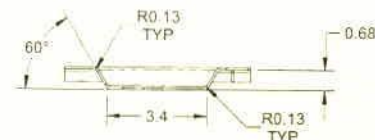
**SECTION D-D**  
SCALE 2X B6-8  
C4-10  
C4-12



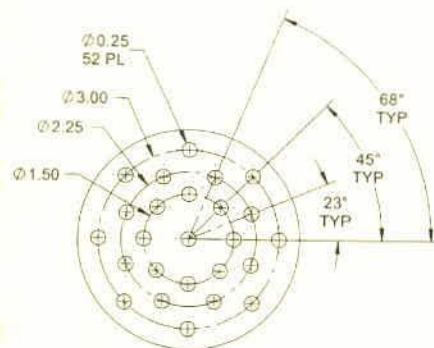
**SECTION E-E**  
SCALE 4X B5-6  
C4-10  
C5-12



**SECTION H-H**  
SCALE 2X CS-8



**SECTION J-J**  
SCALE 2X B6-10



**DETAIL B**  
SCALE 4X B7-7  
2 PL



**DETAIL I**  
SCALE 4X TYP B2-10  
C2-10  
B2-11  
C2-11

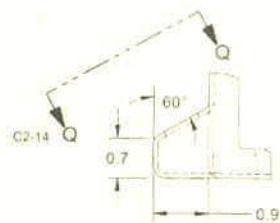
2012-11-05  
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DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 13 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	NTS
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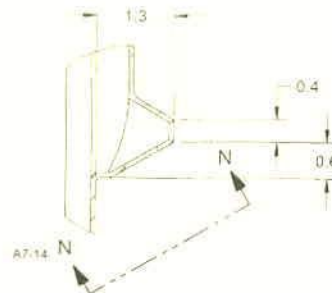




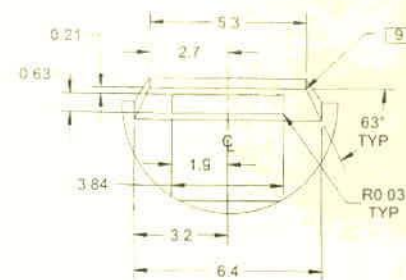
92948



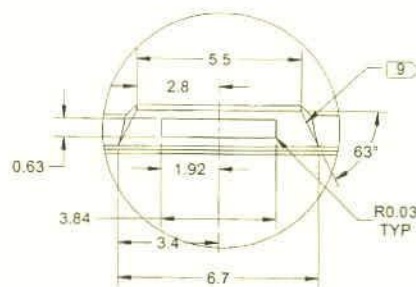
**DETAIL P**  
SCALE 2X B3-11



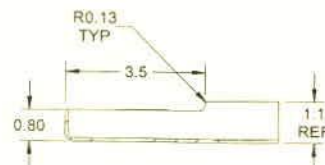
**DETAIL M**  
SCALE 2X C3-7



**DETAIL Q**  
SCALE 0.5X D8-14



**DETAIL N**  
SCALE 0.5X C5-14



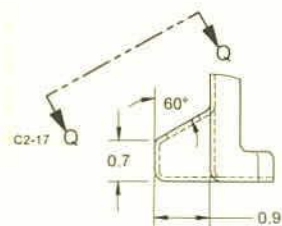
**SECTION O-O**  
SCALE 1.3X B6-11

2012-11-05  
NAP

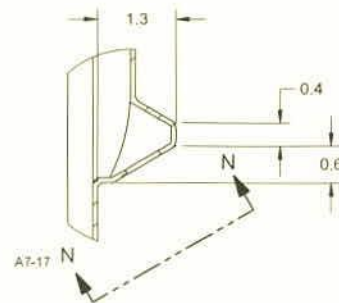
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D4634	SHEET 14 OF 14
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	CENTER CEILING PANELS	HTS
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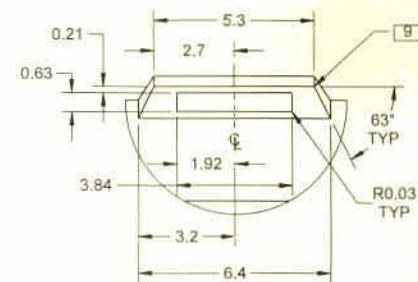




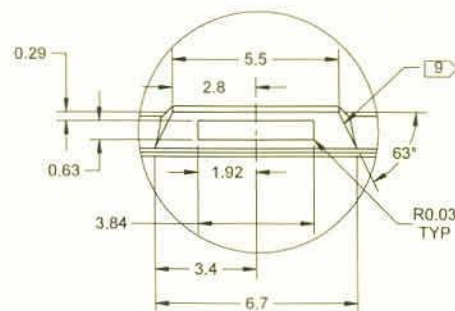
**DETAIL P** B3-14  
SCALE 2X



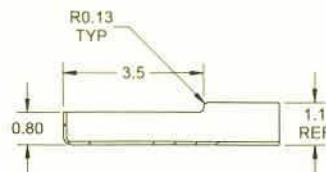
**DETAIL M** C3-10  
SCALE 2X



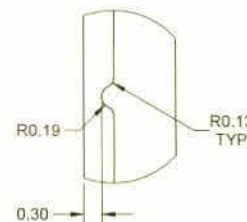
**DETAIL Q** B4-15  
SCALE 0.5X D8-17



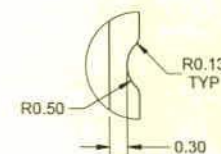
**DETAIL N** C5-17  
SCALE 0.5X B4-15



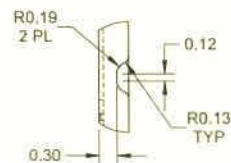
**SECTION O-O** B6-14  
SCALE 1.3X



**DETAIL R** B3-10  
SCALE 4X C3-10  
B2-12



**DETAIL S** B3-10  
SCALE 4X C2-12

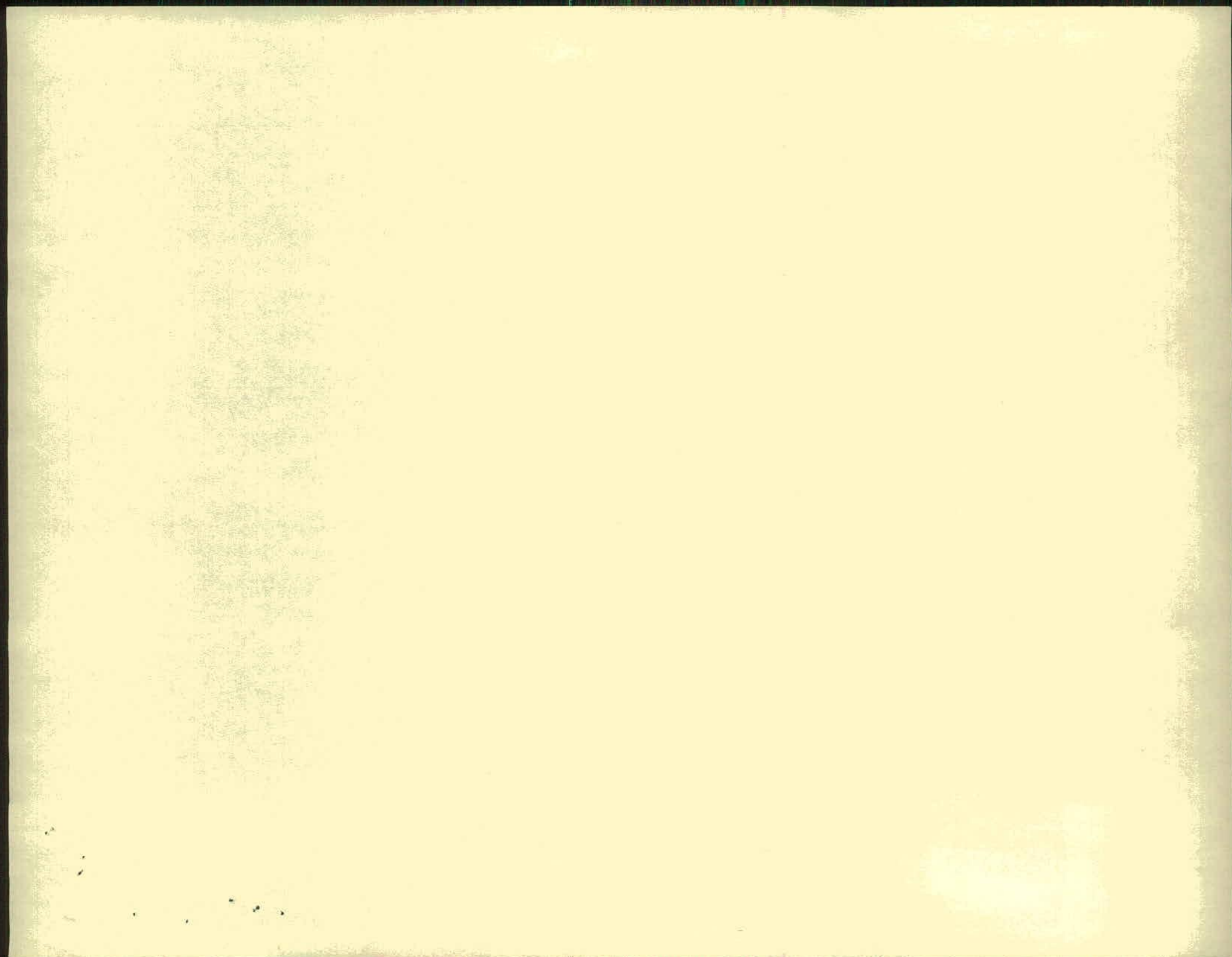


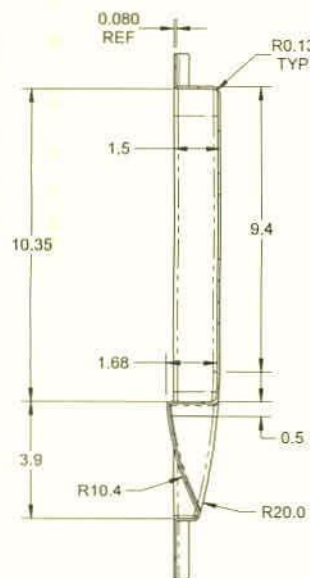
**DETAIL T** C2-14  
SCALE 4X

**PRELIMINARY ISSUE**

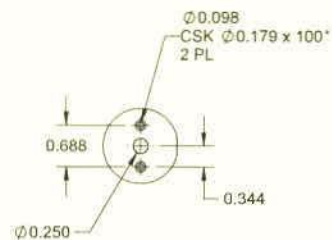
12.11.30

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
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MFG. APPR.		D4634	SHEET 17 OF 17
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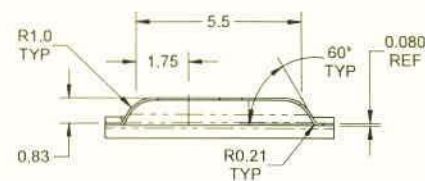




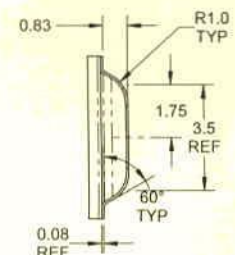
**SECTION G-G** C5-11  
SCALE 4X



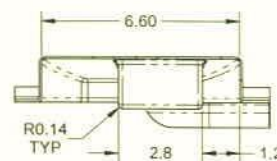
**DETAIL C** B7-10  
SCALE 4X B4-12  
B4-14



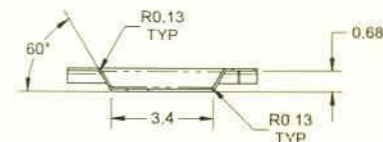
**SECTION D-D** B6-11  
SCALE 2X C4-13  
C4-15



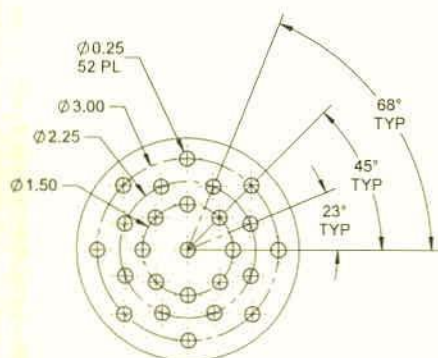
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C5-15



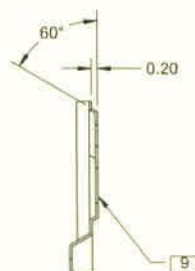
**SECTION H-H** C5-11  
SCALE 2X



**SECTION J-J** B6-13  
SCALE 2X




**DETAIL B** B7-10  
SCALE 4X  
2 PL



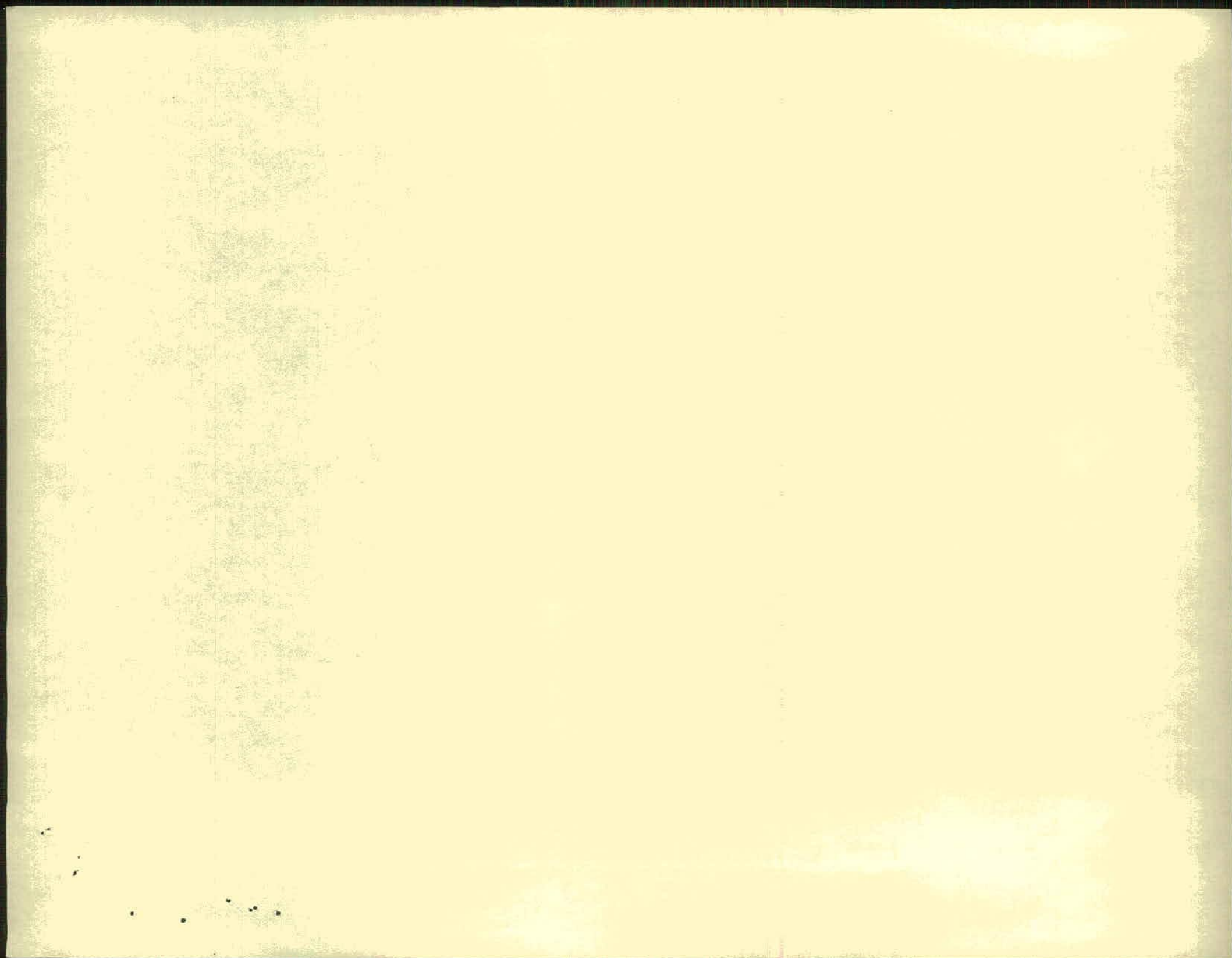
**DETAIL L** B2-13  
SCALE 4X C2-13  
TYP B2-14  
C2-14

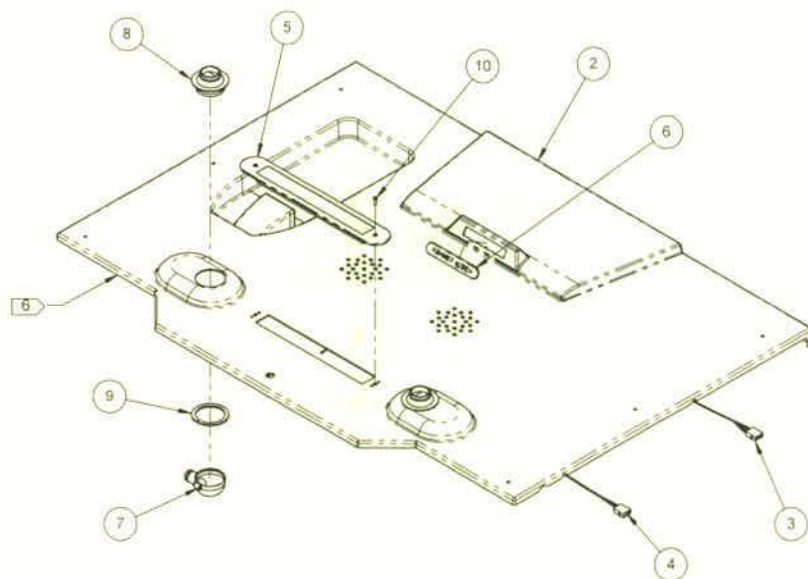
**PRELIMINARY ISSUE**

12.11.30

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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PB3
MFG. APPR.		D4634	SHEET 16 OF 17
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DE APPR.		<b>CENTER CEILING PANELS</b>	
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**D4634-041 FWD, CENTER CEILING PANEL ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.5 lbs
- 8) INSTALL D4728-047/051 WIRE HARNESS PER QSI 048

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4634-041	FWD, CENTER CEILING PANEL ASSY
2	1	D4634-141	FWD, CENTER CEILING REPLACEMENT PANEL ASSY
3	1	D4728-047	ADVISORY LIGHT (FWD) HARNESS ASSEMBLY
4	1	D4728-051	CABIN LIGHT #1 HARNESS ASSEMBLY
5	1	D4638-1	LED LIGHT
6	1	D4645-1	NO SMOKING & FASTEN BELT LIGHT
7	2	D4646-1	PLENUM CAP ASSEMBLY
8	2	D4652-1	AIR VALVE
9	2	D4652-3	MOUNTING NUT
10	2	MS24694-S5	SCREW
11	8	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

**PRELIMINARY ISSUE**

*RF* 12.11.30

PB3	ADDED D4634-141/-143/-145 (ZN B4-7, B4-8, B4-9) REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. PB3
MFG. APPR.		D4634	SHEET 1 OF 17
APPROVED		TITLE	SCALE
DE APPR.		CENTER CEILING PANELS	N/A
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